

Work Order ID 54871

January 4, 2010 1:14:13 PM



Page 1

Item ID: D3267-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket lid Assembly (Outside)

Start Date: 1/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3267

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267
2-Cut (4) D2236-1 From D3166-3 13-Drill holes in tubing D3267-041 as per Dwg D3267
4-Deburr & Remove All Markings From Material 15-Weld D3267-041 Assembly using Welding Table and c

SY 10/01/13 *(1x)*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

GP 10/01/13

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

→ 5.10.10.17

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54871

January 4, 2010 1:14:13 PM



Page 2

Item ID: D3267-041

Accept



Setup Start



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Item Name: Basket lid Assembly (Outside)

Start Date: 1/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation

Description PRESSURE - WASH

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1ST COAT: START TIME: 2:00pm - 4:00pm OVEN

TEMPERATURE: 2:00pm FINISH TIME:

2:45pm ***** 2nd coat if

necessary ***** 2ND COAT: START TIME:

3:15pm OVEN TEMPERATURE:

=> MU 10-01-20 (X) 8

140

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Wing walk as per Dwg D3267 and QSI 005 4.4: ISpray Paint

Black: M11259 Wing Walk: M112900

=> MU 10-0122

(X) 9

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> m-l 10/01/25 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54871

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January 4, 2010 1:14:18 PM

Item ID: D3267-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket lid Assembly (Outside)

Start Date: 1/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/26

NF 10-1-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 4, 2010 1:14:05 PM

Page 1

Work Order ID: 54871

Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)


Start Date: 1/04/10

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3  Spacer Bushing		Manufactured	No			100	Each	33.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

33

44274

4

44365

9

54135

20

2x *SY 10/01/12*

D2506

Manufactured

No

100

Each

8.0000

1.0000

Label Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

44275

1

Main Warehouse

WA

7

52834

1

54136

6

1x *SY 10/01/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 4, 2010 1:14:05 PM

Page 2

Work Order ID: 54871



Parent Item: D3267-041



Parent Item Name: Basket lid Assembly (Outside)

Start Date: 1/04/10

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	18.0000	2.0000			



Mounting Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

46086

2

48428

1

51120

9

Main Warehouse

WA

6

50872

1

51745

5

2x *SY* 10/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 4, 2010 1:14:07 PM

Page 3

Work Order ID: 54871

Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 1/04/10

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-3		Manufactured	No			100	Each	16.1028	1.0000			



Basket Hoop

Warehouse Loc Qty Loc Code

Location

Main Warehouse

53494

5.102775

53494

5.102775

Main Warehouse

ST

5

48429

5

Main Warehouse

WA

6.000014474

52058

1.4474E-05

54018

6

M304EX0.75-16F

Purchased

No

100

sf

383.7329

8.2105



Expanded Metal Flat SS

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

383.7329065

110134

3.4

111956

0.000017

112147

9.4736E-06

112949

43.42358

113205

16.9093

113497

320

1x SH 10/01/12

113.2105 SH 10/01/12
8.2105

END Shift

8.19PC

8.6788

January 4, 2010 1:14:07 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 4, 2010 1:14:07 PM

Work Order ID: 54871

Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)


Start Date: 1/04/10

Required Date: 1/15/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	314.4400	32.2105			
												
304 SQ Tube .75x.75x.065W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	314.4399742	
113082	0.00419	
113245	314.435784	
Main Warehouse		
WA	0.0000047	
112398	0.0000047	

32.2105 *SH* 10/01/12
 END BAR
 Scrape 1" picks

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

RELEASED
08 07 04 14

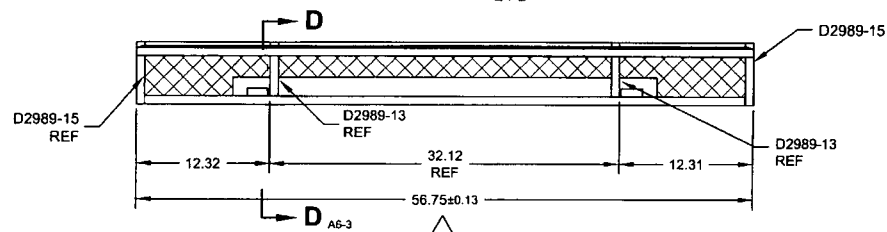
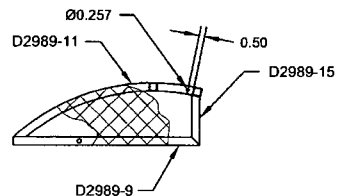
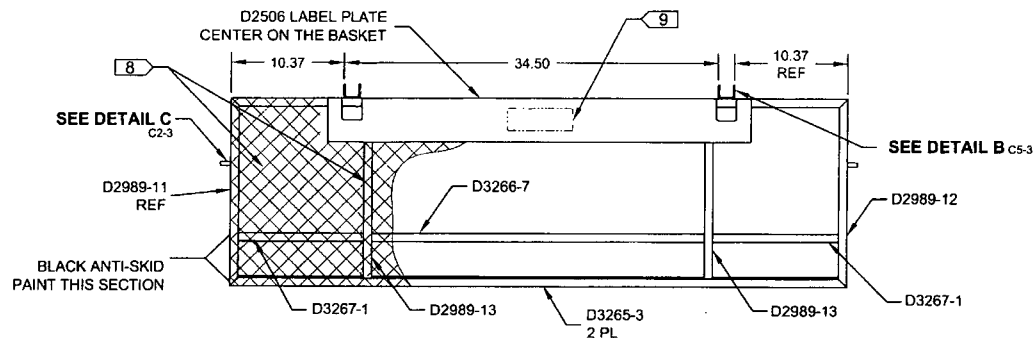


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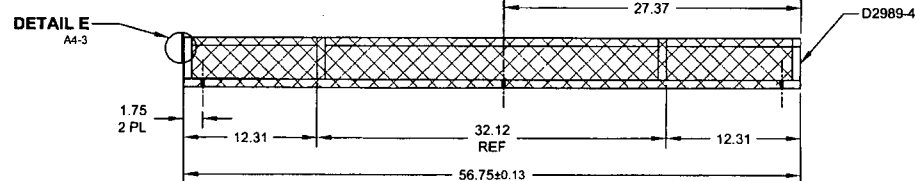
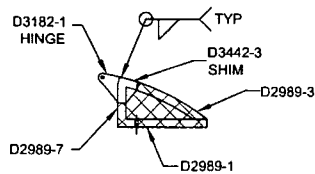
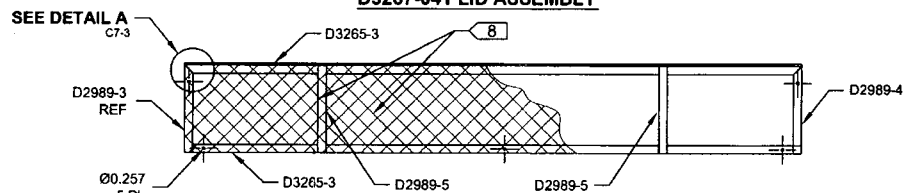
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3267	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1



D3267-041 LID ASSEMBLY



D3267-041 LID ASSEMBLY







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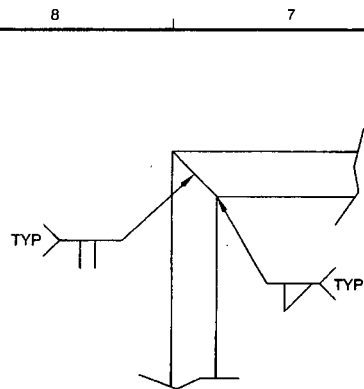
- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

Wd
5/8/87

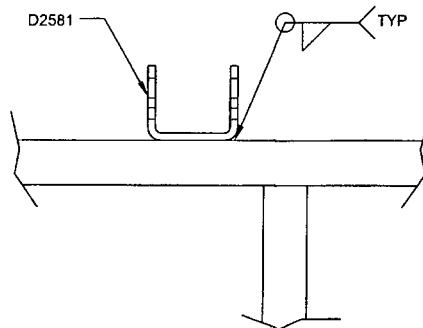
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08-07-04/17

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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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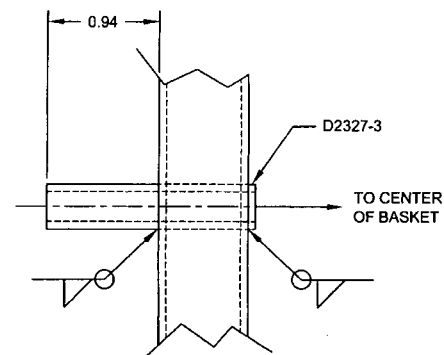
8 7 6 5 4 3 2 1



DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X

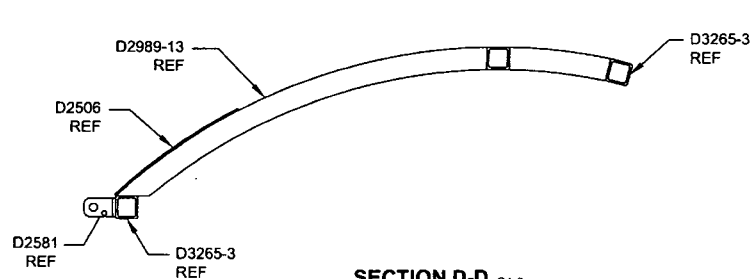


DETAIL B D2-2
2 PL
SCALE 2X

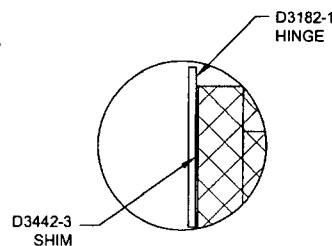


DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X

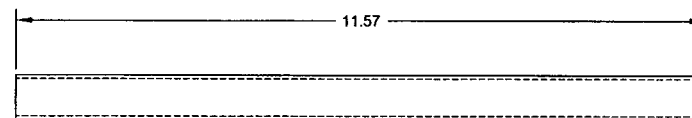
WLO 54871



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

RELEASED
08.08.15

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3267	3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSMEBLY	NTS
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